

11-500 049W

# Work Order ID 71841

Wednesday, July 13, 2011 10:20:46 AM



Page 1

Item ID: D3490-1

Accept



Setup Start



Revision ID:

Item Name: Cross Bolt Spacer

Stop



Start Date: 7/14/2011 Start Qty: 60.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 60.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 11-07-13

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3490	Rev A

100



Hardinge CNC LATHE SMALL

0.00

65 ⚡

Hardinge

Hardinge CNC Lathe Small

Memo

1-TURN AS PER FOLIO FA628 & DWG D3490

FOLIO REV: 1

DWG REV: 1

2-DEBURR AS REQUIRED

0.00

11/17/13

110



QC2- Inspect parts off machine FAI/FAIB

0.00

65 ⚡

QC

Quality Control

Memo

0.00

11/17/13

120



QC8- Inspect parts - second check

0.00

11-07-20

QC

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 71841**

Wednesday, July 13, 2011 10:20:46 AM



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Item ID: D3490-1

Revision ID:

Item Name: Cross Bolt Spacer

Start Date: 7/14/2011 Start Qty: 60.00

Accept



Setup Start



Stop



Required Date: 7/28/2011 Req'd Qty: 60.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

130



Packaging

Packaging

Operation  
DescriptionIdentify as per dwg & Stock Location: LGSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

0.00

0.00

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

0.00

65 0 8/16/201111/12/2011MF  
11-07-2011

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Wednesday, July 13, 2011 10:20:44 AM

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Work Order ID: 71841



Parent Item: D3490-1



Parent Item Name: Cross Bolt Spacer

Start Date: 7/14/2011

Required Date: 7/28/2011

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP Rev:A New Issue 06-03-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6T0.500W.049



Purchased

No

100

f

319.3512

0.266

16.8

6061-T6 RD Tube .500 x.049W

Location

MAT014

Loc Qty

319.351211

Loc Code

319.351211

2011/7/20  
18 ft

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	71841
Description: Crossbolt Spacer	Part Number:	D3490-1
Inspection Dwg: D3490	Rev: A	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

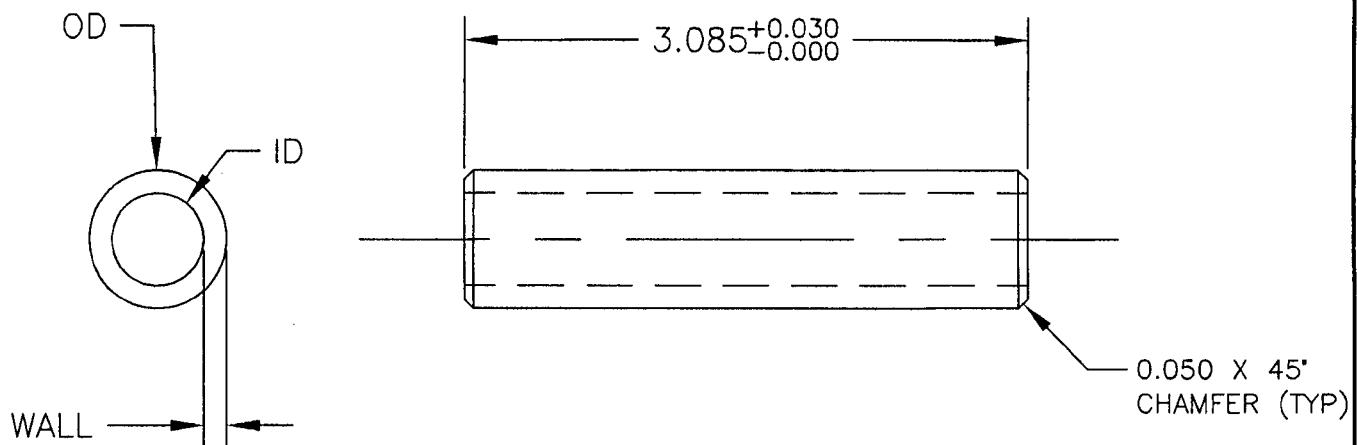
## X First Article      Prototype

Measured by: <u>SJ</u>	Audited by: <u>SJ</u>	Prototype Approval: N/A
Date: <u>1/17/20</u>	Date: <u>1-17-20</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	06.10.06	New Issue	KJ/JLM	
B	08.06.02	Dimensions and tolerances revised	KJ/DD	
C	08.10.07	0.050 x 45° dimension revised	KJ/DD	

**DART**

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3490	REV. A SHEET 1 OF 1
DATE 06.01.04		TITLE CROSS BOLT SPACER	SCALE NTS
A	06.01.04	NEW ISSUE	

**D3490-1/-3/-5 CROSS BOLT SPACER PARTS LIST**

PART NUMBER	OD	WALL	ID (REF)	MATERIAL SPEC
D3490-1	0.500	0.049	0.402	M6061T6T0.500W.049
D3490-3	0.750	0.080	0.591	M6061T6R0.750
D3490-5	0.313	0.058	0.197	M6061T6T0.313W.058

**D3490-1/-3/-5 CROSS BOLT SPACER**

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

*[Handwritten initials]*  
**RELEASED**  
06-02-07

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